

Date: Thursday, 3/20/2008 9:54:23 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TURNING DETAIL FOR D2894-1
Job Number : 38132	
Estimate Number : 13235	
P.O. Number :	Part Number : DSK079
This Issue : 3/20/2008 S.O. No. :	Drawing Number : DSK079 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run :	Material :
Written By : <u>                    </u>	Due Date : 4/3/2008 Qty: 10 Um: Each
Checked & Approved By : <u>                    </u>	
Comment : est rev A. 08.03.13 new issue EC	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0 D6104009 17-4 SS Roundbar 5.25"OD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Billet

Batch: B 38213mf 08/04/12

10

2.0 MORI SEIKI

MORI SEIKI CNC LATHE LARGE



(P10)

Comment: MORI SEIKI CNC LATHE LARGE

Turn blank as per Folio FA253

mf 08/04/12

10

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf 08/04/12

10

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

BC 08-04-14

(9)

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock in Kanban

Location:                     mf 08/04/14

(9)

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/15

Job Completion

mf08-04-15

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DSK 079 PAR #: N/A Fault Category: Prod / Machine NCR: Yes No DQA: LD Date: 08/04/16  
 QA: N/C Closed: LD Date: 08/04/16

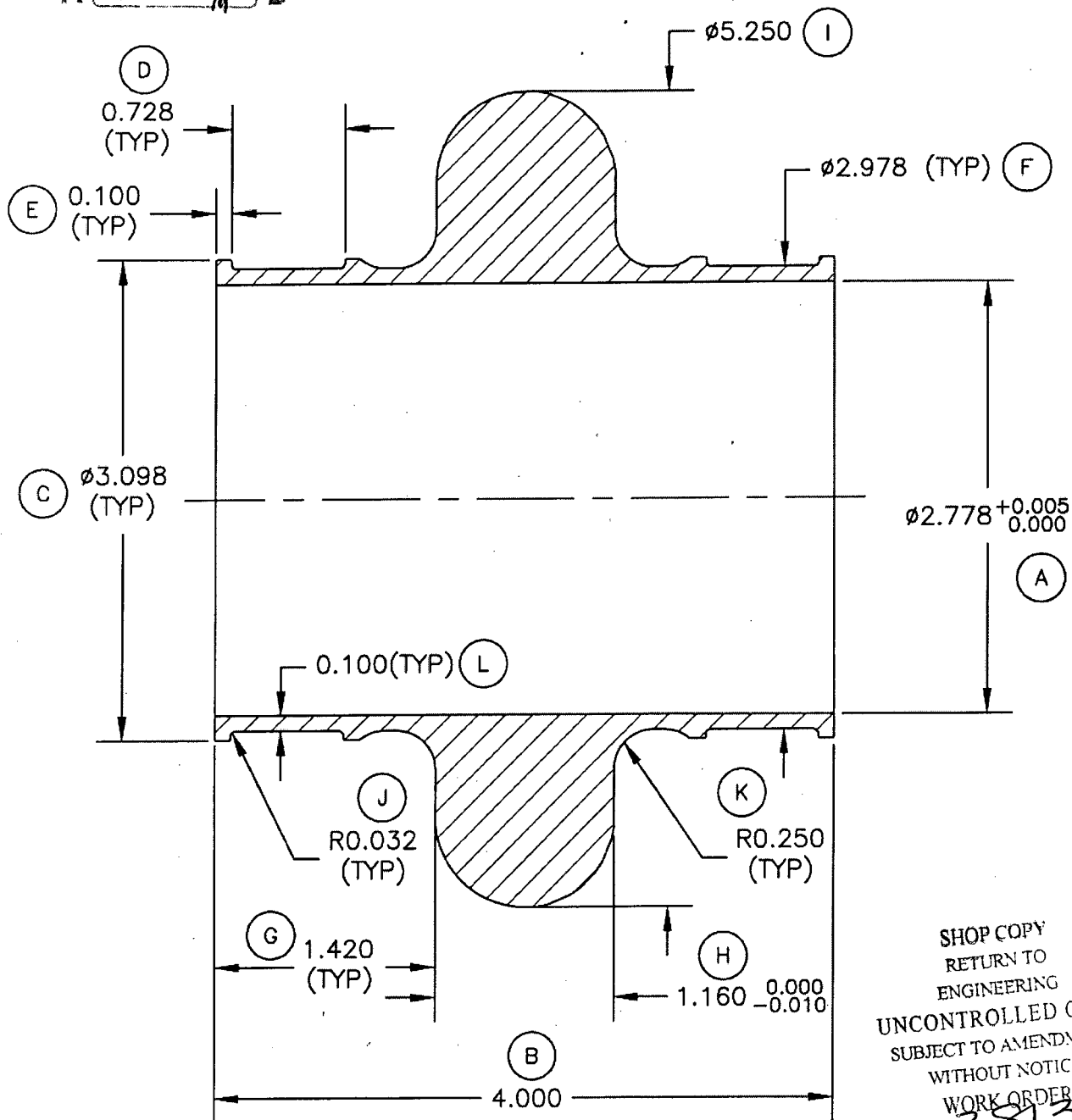
NCR: <u>38132</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/04/13</u>	<u>2.0</u>	<u>1 piece scrap the .250 rad profile too deep and too big. R.C. program error.</u>	<u>[Signature]</u> <u>08/04/14</u>	<u>use part for setup only</u> <u>stamp for setup only</u>	<u>[Signature]</u> <u>08/04/14</u>	<u>56</u> <u>08.04.14</u>	<u>[Signature]</u> <u>08/04/14</u>	<u>[Signature]</u> <u>08/04/14</u>

NOTE: Date & initial all entries



DESIGN AF	DRAWN BY AF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED AF	APPROVED AF	DRAWING NO. DSK 079	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2894-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED  
03.07.01



D2894-1 TURNING DETAIL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38132

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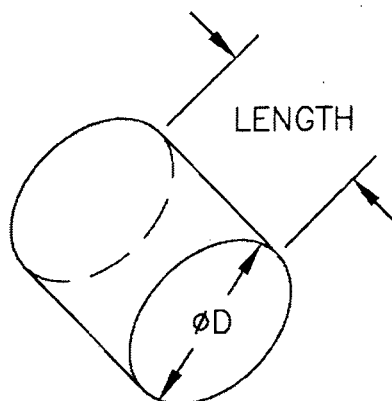
1.250  
640



DESIGN E.F.	DRAWN BY 	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D6104	Rev. B SHEET 1 OF 1
DATE 02.11.25		TITLE ROUND BILLET, 17-4	SCALE NTS
A	01.04.10	NEW ISSUE	
B	02.11.25	CLARIFY ALLOY SPEC ADDED D6104-009/-011 REDUCE LENGTH OF BILLETS	

RELEASED  
02.11.25

## SPECIFICATION CONTROL DRAWING



MATERIAL: 17-4 PH SS (AMS 5643 OR AISI 630) MIN UTS = 170 KSI (38 HRC)

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES

Part No.	Alloy	D (Diameter)	Length
D6104-001	17-4 PH STAINLESS STEEL	Ø3.00	3.80
D6104-003	17-4 PH STAINLESS STEEL	Ø3.25	3.80
D6104-005	17-4 PH STAINLESS STEEL	Ø4.00	5.10
D6104-007	17-4 PH STAINLESS STEEL	Ø4.50	5.10
D6104-009	17-4 PH STAINLESS STEEL	Ø5.25	4.10
D6104-011	17-4 PH STAINLESS STEEL	Ø6.50	4.10

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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 38 / 32
<b>Description: Ø2.750 Support</b>	<b>Part Number:</b> D2894-1
<b>Inspection Dwg: D2894 Rev. B1</b>	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2894 Rev B1/DSK079 Rev A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
<b>Lathe Section</b>									
A	2.778	2.783		2.782	2.781	2.779	2.780		
B	3.990	4.010		4.000	3.996	3.995	3.990		
C	3.088	3.108		3.099	3.099	3.099	3.099		
D	0.718	0.738		.725	.725	.725	.725		
E	0.090	0.110		.100	.106	.100	.091		
F	2.968	2.988		2.979	2.979	2.979	2.979		
G	1.410	1.430		1.499	1.419	1.417	1.415		
H	1.150	1.160		1.160	1.166	1.166	1.160		
I	5.240	5.260		5.249	5.250	5.250	5.250		
J	0.022	0.042		.032	.032	.032	.032		
K	0.240	0.260		.250	.250	.250	.250		
L	0.090	0.110		.098	.098	.099	.099		
M									
<b>HAAS Section</b>									
AA	0.454	0.474							
AB	3.062	3.082							
AC	0.053	0.073							
AD	0.971	0.991							
AE	1.766	1.786							
AF	0.020	0.040							
AG	0.257	0.262	DT8683						
AH	0.053	0.073							
AI	3.04	3.10							
AJ	1.990	2.010							
AK	0.240	0.260							
AL	1.884	1.904							
AM	0.500	0.505	DT8708						
AN	0.189	0.194							
<b>Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"</b>									
<b>Accept/Reject</b>									

<b>Measured by:</b> <i>mf</i>	<b>Audited by:</b> <i>sc</i>
<b>Date:</b> 08/04/14	<b>Date:</b> 08.04.14

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM <i>JA</i>	<i>BE</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 38132
<b>Description:</b> Ø2.750 Support	<b>Part Number:</b> D2894-1
<b>Inspection Dwg:</b> D2894 Rev. B1	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2894 Rev B1/DSK079 Rev A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	37	48		
<b>Lathe Section</b>									
A	2.778	2.783		2.779	2.779	2.781	2.780		
B	3.990	4.010		3.997	3.996	3.997	3.996		
C	3.088	3.108		3.099	3.099	3.099	3.099		
D	0.718	0.738		.726	.726	.726	.726		
E	0.090	0.110		.100	.100	.100	.100		
F	2.968	2.988		2.980	2.980	2.980	2.980		
G	1.410	1.430		1.416	1.416	1.420	1.420		
H	1.150	1.160		1.160	1.160	1.160	1.159		
I	5.240	5.260		5.250	5.250	5.250	5.250		
J	0.022	0.042		.032	.032	.032	.032		
K	0.240	0.260		.250	.250	.250	.250		
L	0.090	0.110		.099	.099	.099	.099		
M									
<b>HAAS Section</b>									
AA	0.454	0.474							
AB	3.062	3.082							
AC	0.053	0.073							
AD	0.971	0.991							
AE	1.766	1.786							
AF	0.020	0.040							
AG	0.257	0.262	DT8683						
AH	0.053	0.073							
AI	3.04	3.10							
AJ	1.990	2.010							
AK	0.240	0.260							
AL	1.884	1.904							
AM	0.500	0.505	DT8708						
AN	0.189	0.194							
<b>Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"</b>									
<b>Accept/Reject</b>									

<b>Measured by:</b> gmf	<b>Audited by:</b> BG
<b>Date:</b> 08/04/14	<b>Date:</b> 08/04/14

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 38132
<b>Description: Ø2.750 Support</b>	<b>Part Number:</b> D2894-1
<b>Inspection Dwg: D2894 Rev. B1</b>	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2894 Rev B1/DSK079 Rev A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				19	210	311	412		
<b>Lathe Section</b>									
A	2.778	2.783		2.780					
B	3.990	4.010		3.997					
C	3.088	3.108		3.099					
D	0.718	0.738		.727					
E	0.090	0.110		.100					
F	2.968	2.988		2.980					
G	1.410	1.430		1.418					
H	1.150	1.160		1.156					
I	5.240	5.260		5.250					
J	0.022	0.042		.032					
K	0.240	0.260		.250					
L	0.090	0.110		.099					
M									
<b>HAAS Section</b>									
AA	0.454	0.474							
AB	3.062	3.082							
AC	0.053	0.073							
AD	0.971	0.991							
AE	1.766	1.786							
AF	0.020	0.040							
AG	0.257	0.262	DT8683						
AH	0.053	0.073							
AI	3.04	3.10							
AJ	1.990	2.010							
AK	0.240	0.260							
AL	1.884	1.904							
AM	0.500	0.505	DT8708						
AN	0.189	0.194							
<b>Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"</b>									
<b>Accept/Reject</b>									

<b>Measured by:</b> <i>and</i>	<b>Audited by:</b> <i>SE</i>
<b>Date:</b> 08/04/14	<b>Date:</b> 08.04.14

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM <i>JA</i>	<i>BE</i>